Work Order ID 74538

Tuesday, October 04, 2011 8:21:38 AM

Item ID: D3213-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Door Panel

Start Date: 9/30/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** M L J **Date:** 11/10/04 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3213	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00				B11-10-29			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3213 ☐Dwg Rev: B ☐Prog Rev: B ☐2-								
2024 .063	Deburr if necessary								
						20			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						FB11-10-29			
Quality Control	**Memo**	0.00							
120	QC8- Inspect parts - second check	0.00							
QC						M 11 10 31 (20)			
Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 74538

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				20	BR 11-1-11		
Small Fab	**Memo**	0.00							
Small Fab	Deburr								
140	Chemical Conversion Coat per QSI005 4.1	0.00				20 X	ØM 11/4/01		
HandFinish	**Memo**	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00				11/11/11		(20)	
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 74538

Tuesday, October 04, 2011 8:21:38 AM

Item ID: D3213-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Door Panel

Start Date: 9/30/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 232A	0.00				11/11/01		22	
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00						11/11/01	
QC	**Memo**	0.00							
Quality Control									

MF 11-11-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 04, 2011 8:21:44 AM

Work Order ID: 74538

Parent Item: D3213-1

Parent Item Name: Door Panel

Start Date: 9/30/2011 **Required Date:** 10/14/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments:
IPP Rev:A 05-11-17 New Issue JLM
IPP Rev:B 07-02-13 Now on Waterjet JLM
IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	115.5000	0.4714	4.962105			
2024-T3 .063 sheet													

Location	Loc Qty	Loc Code
MAT022	115.5	
117392	115.5	

B11-10-09

117392

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74538
Description: Door Panel	Part Number:	D3213-1
Inspection Dwg: D3213 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.00	2		T IBO1	
4.47	+/-0.030	4.479	2		V IBO2	
14.400	+/-0.005	14.400	2		T	
0.300	+/-0.010	.299	2		V	
Ø0.128	+0.005/-0.001	.131	2		V	
Pitch 2.057	+/-0.005	2.059	2		V	

Measured by:	RB
Date:	11-10-29

Audited by:	
Date:	11/10/31

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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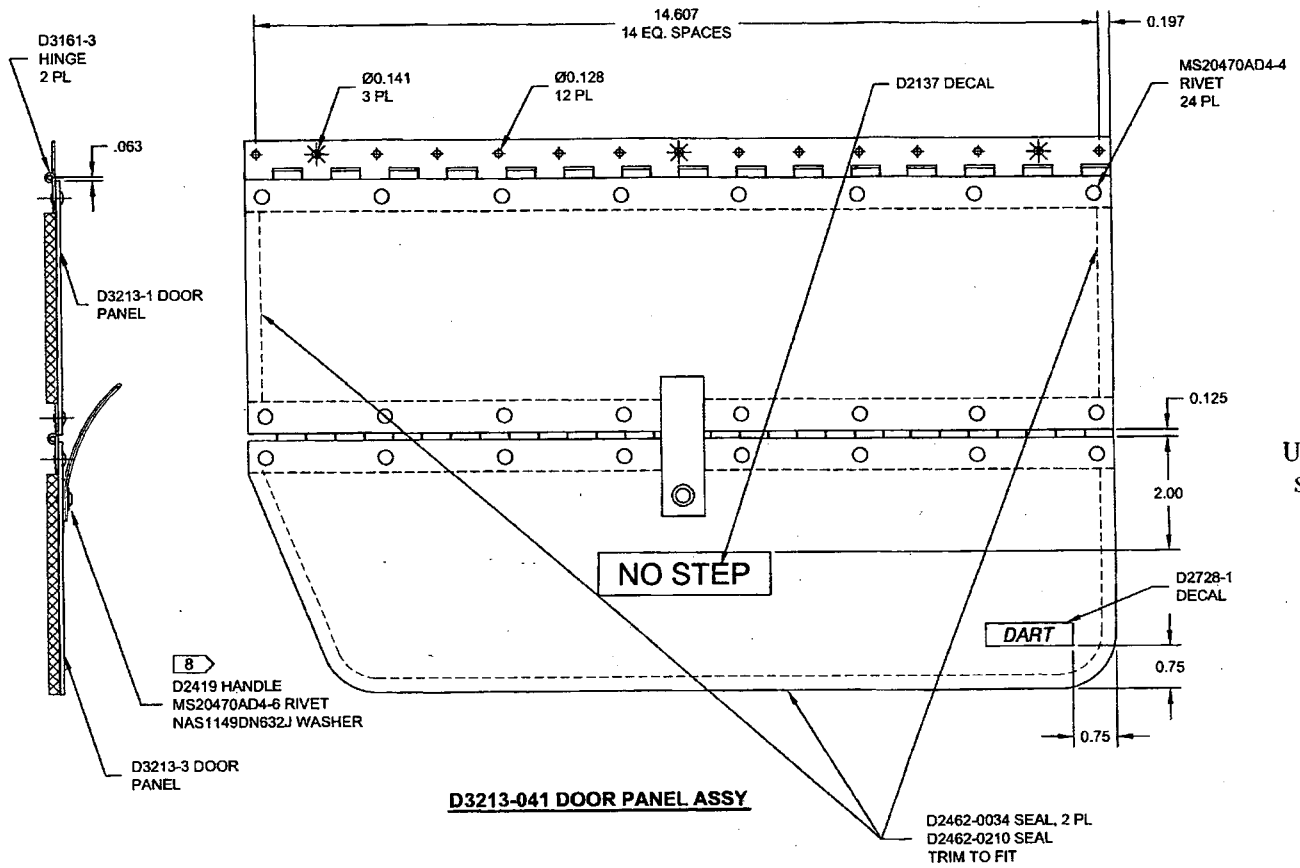
NOTE: Date & initial all entries



D3213-041 DOOR PANEL ASSY

QTY -041	PART NUMBER	DESCRIPTION
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74538 M.L.J
11/10/04

RELEASED
2011-06-14

D3213-041 NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXXX" PER QSI 044 6.6
7) WEIGHT: 1.49 lbs
8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

REV.	DESCRIPTION	BY	DATE
B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	11.06.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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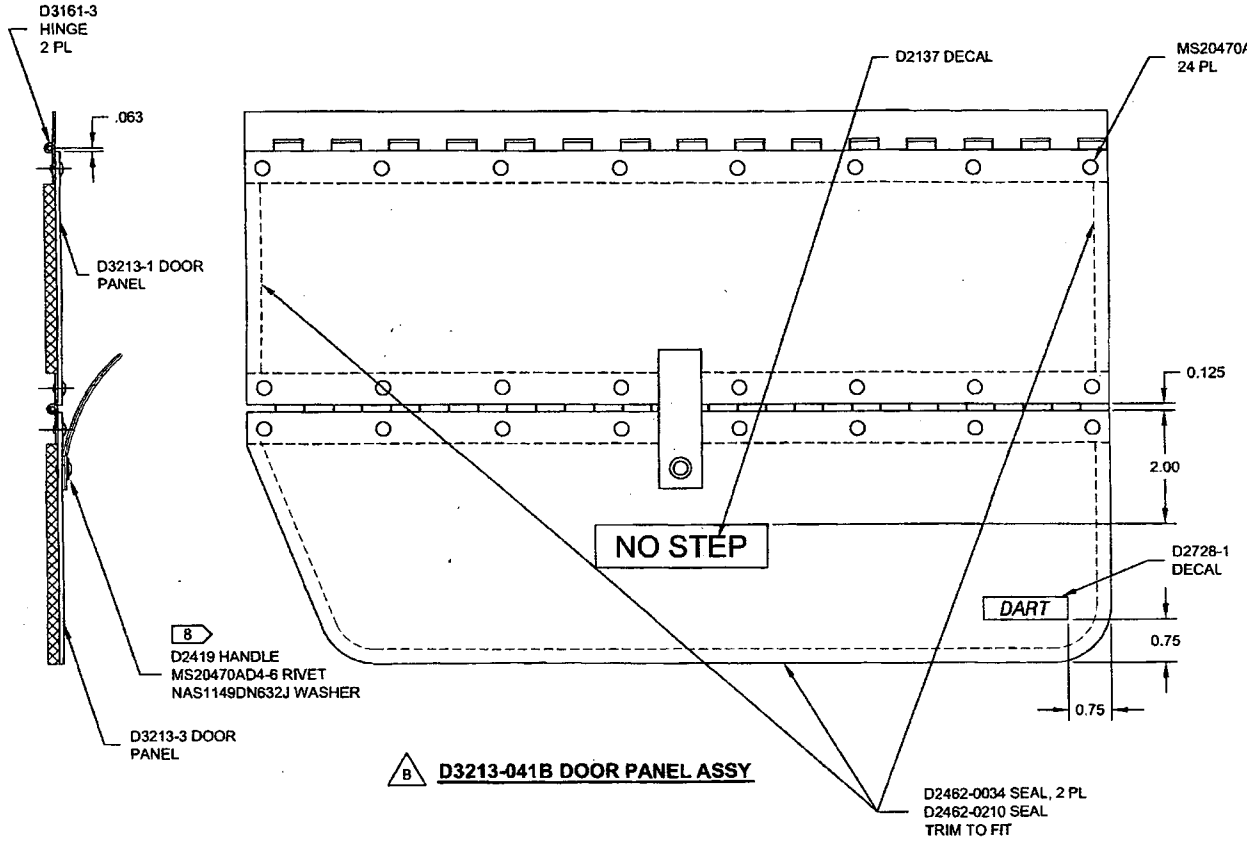
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

74538

QTY -041B	PART NUMBER	DESCRIPTION
X	D3213-041B	DOOR ASSEMBLY, BLANK
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



B **D3213-041B DOOR PANEL ASSY**

RELEASED
2011-06-14

D3213-041B NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXXX" PER QSI 044 6.6
7) WEIGHT: 1.49 lbs
8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. B
MFG. APPR:		D3213 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		DOOR ASSEMBLY NTS
DATE 11.06.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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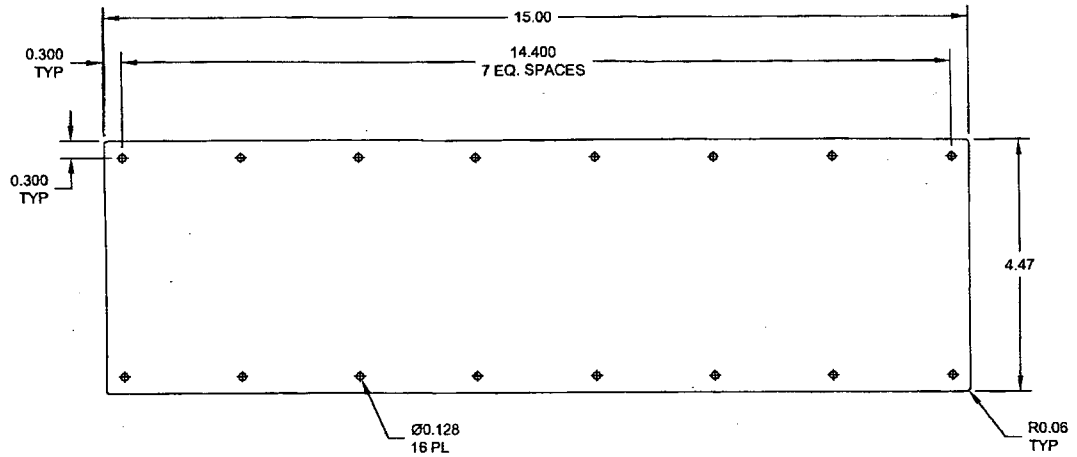
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

74538



D3213-1 DOOR PANEL

RELEASED
2011 -06- 13

D3213-1 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	11.06.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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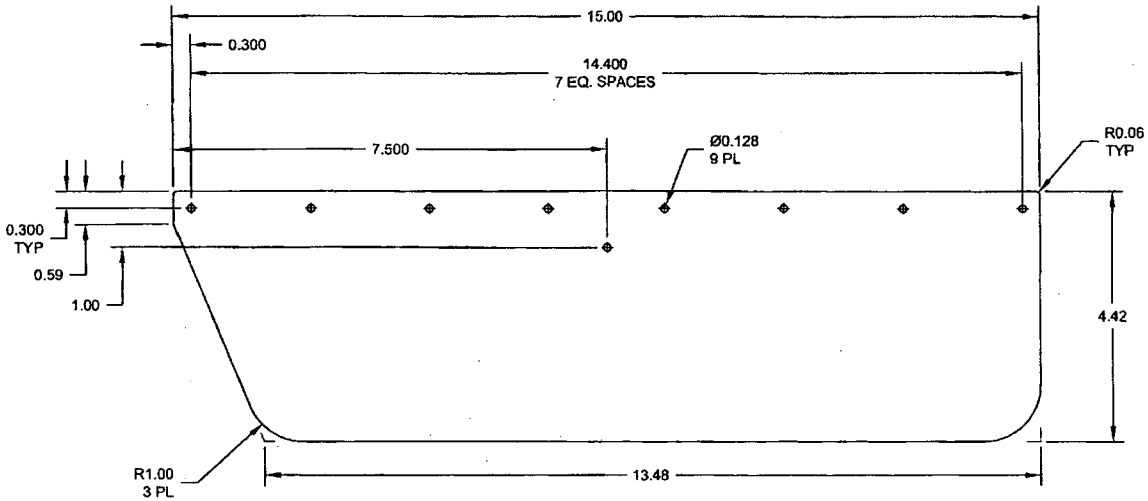
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

74538



D3213-3 DOOR PANEL

RELEASED
2011-06-10

D3213-3 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.39 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	11.06.06		

Dart Aerospace Ltd

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